

5124

SPLIT

DART AEROSPACE LTD		Work Order:	23370 A
Description: Aft Cap		Part Number:	D2646
Dwg: D2646 Rev. B		Qty:	2
Ref:		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.06.07	40
2	PG	Issue P/O: <u>2008094</u> Spin as per Dwg D2646 Material release note required	u	05.06.07	40
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05/06/07	40
4	QC6	Inspect dimensions as per Dwg D2646	2	05.06.14	2
5	GA	Drill using DT8026 as per Dwg D2646. Open holes to <u>19/64"</u> 1250 per dwg	2	05.06.15	2
6	GA	Deburr	2	05.06.15	2
7	FP	Acid etch and alodine as per QSI 005 4.1	2	05.06.15	2
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	N/A		
9	QC3	Inspect Powder Coat			
10	GA	Install Inserts as per Dwg D2646 Pick: <u>per AESSIOKRB116 PH 05.05.16</u> Qty Part Number Description Batch 2 NAS1330C3KB116 Insert M17524	G	05.06.16	2
11	QC5	Inspect work to Step 10	ABH	05.06.20	2
12	PK	Identify and Stock		18.05.06.20	
13	AC	Cost / part: <u>10.15</u>	545	05.08.11	2
14	DC	Close W/O <u>7.37</u> Inspect Level 21	HJ	05.07.20	2

Rev	Date	Change	Revised By	Approved
C	98.01.16	Changed Inspection Levels	BW	
D	99.01.04	Added Powder Coat	DM	
E	00.06.22	Removed P/O for powder coat	EC	
F	05.06.07	Reformat	KJ/JLM	

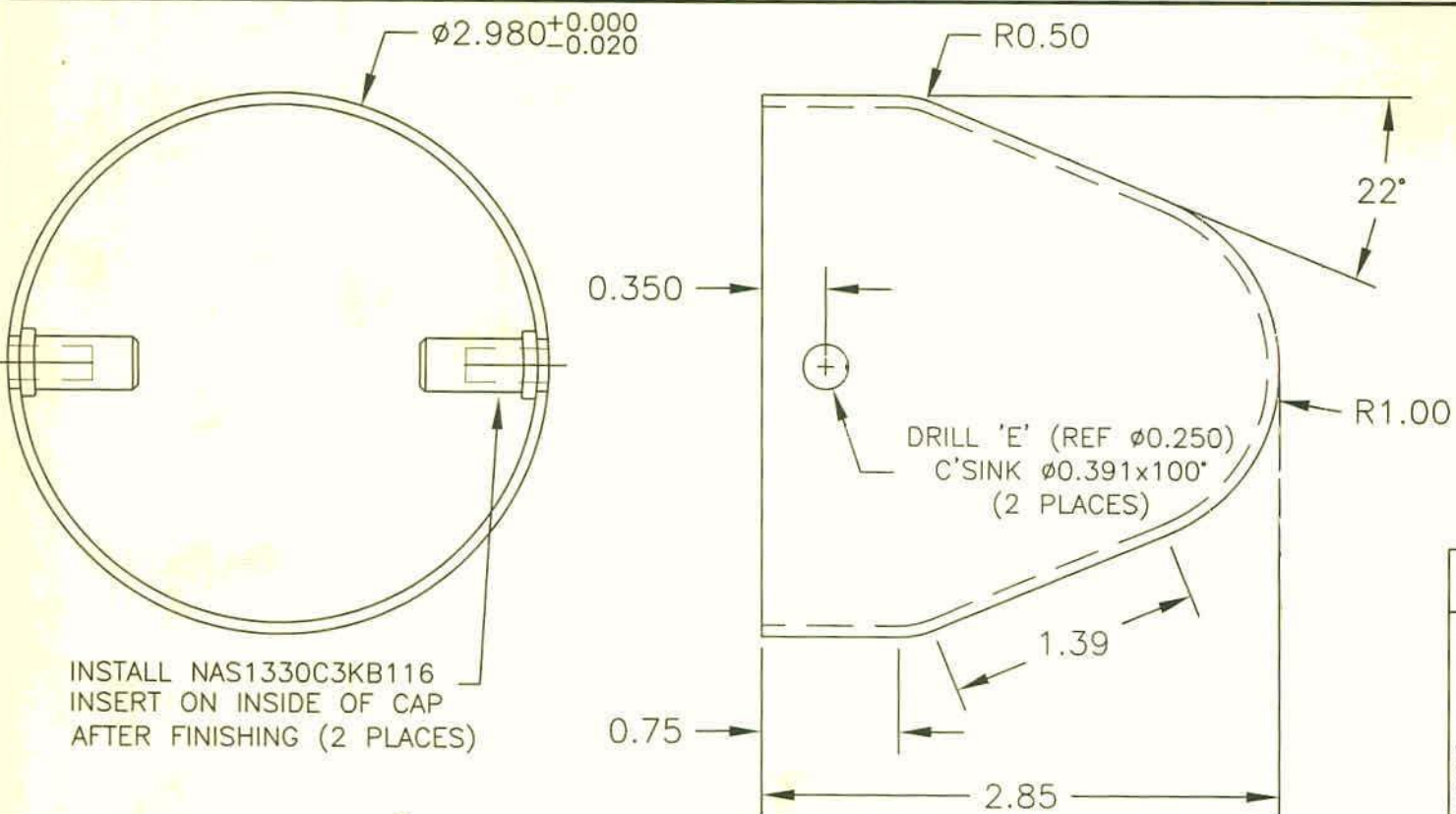
RELEASED

11.05.20



REFERENCE ONLY

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.	
CHECKED		APPROVED		DRAWING NO.	PORT HADLOCK, WA
DATE	05.04.01			D2646	REV. B
				TITLE	SHEET 1 OF 1
				AFT CAP	SCALE
					1:1
A		97.03.25		NEW ISSUE	
B		05.04.01		CHANGE TO CLOSED INSERTS	



D2646 AFT CAP

- 1) MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 18, 2005
03:08 pm

Work Order No : 0023370
Project Name : D2646
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D2646
Description : Aft Cap
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 05-18-05
Est Finish Date : 06-22-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00